



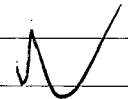


Sup 12/02

Work Order ID 66491

Wednesday, February 16, 2011 12:08:30 PM




Item ID: D3255-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Access Panel Assembly
Start Date: 2/16/2011 Start Qty: 2.00  Cust Item ID:
Required Date: 2/18/2011 Req'd Qty: 2.00  Customer:


Reference:
Approvals: Process Plan:  Date: Tooling: Date: Run Start 
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------


Draw Nbr	Revision Nbr								
D3255	Rev B								

100  Large Fab 0.00
Large Fab Memo 0.00
Large Fab 1-Weld as per Dwg D3255 ***purge weld*** ☐ A/R SS ROD
Batch: 1114507 ☐ 2-Grind Welds Flush

EL 11-2-17 (23)

110  QC 0.00
Quality Control Memo 0.00

(+3)

120  QC 0.00
Quality Control Memo 0.00

(+5)

Work Order ID 66491

Wednesday, February 16, 2011 12:08:30 PM



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Item ID:	D3255-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Access Panel Assembly					
Start Date:	2/16/2011	Start Qty:	2.00		Cust Item ID:	
Required Date:	2/18/2011	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>M115138</i> Memo START TIME: <i>10:10</i> <input type="checkbox"/> OVEN TEMPERATURE: <i>320°</i> <input type="checkbox"/> FINISH TIME: <i>10:10</i>	0.00 0.00				<i>3</i>	<i>11-02-23</i>		
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>3</i>	<i>11/02/23</i>		
150 Small Fab Small Fab	Small Fab Memo 1-Bond D3255-5 gasaket to d3255-041 using Dow corning adhesive as per Dwg D3255 A/R 736 DOW CORNING ADHESIVE Batch: <i>M116664</i>	0.00 0.00						<i>11/02/24(3)</i>	

Work Order ID 66491

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Wednesday, February 16, 2011 12:08:30 PM

Item ID: D3255-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Access Panel Assembly

Start Date: 2/16/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/18/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/16/24

x3
041

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

PAP6649D

11/2/24 (3)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/24 JF

MF
11-02-24

Picklist Print

Wednesday, February 16, 2011 12:08:28 PM

Page 1

Work Order ID: 66491

Parent Item: D3255-041

Parent Item Name: Access Panel Assembly




Start Date: 2/16/2011

Required Date: 2/18/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3255-1  Panel		Manufactured	No			100	Each	3.0000	1	2			
<div> <div>Location</div> <div>ST176</div> <div>61246</div> </div> <div> <div>Loc Qty</div> <div>3</div> <div>3</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3255-3  Cap		Manufactured	No			150	Each	9.0000	1	2			
<div> <div>Location</div> <div>WA</div> <div>48315</div> <div>WA21</div> <div>63587</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> <div>7</div> <div>7</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div>													
D3255-5  Gasket		Manufactured	No			100	Each	5.0000	1	2			
<div> <div>Location</div> <div>ST044</div> <div>63588</div> </div> <div> <div>Loc Qty</div> <div>5</div> <div>5</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

2 11-2-17

3

2 11-2-17

3

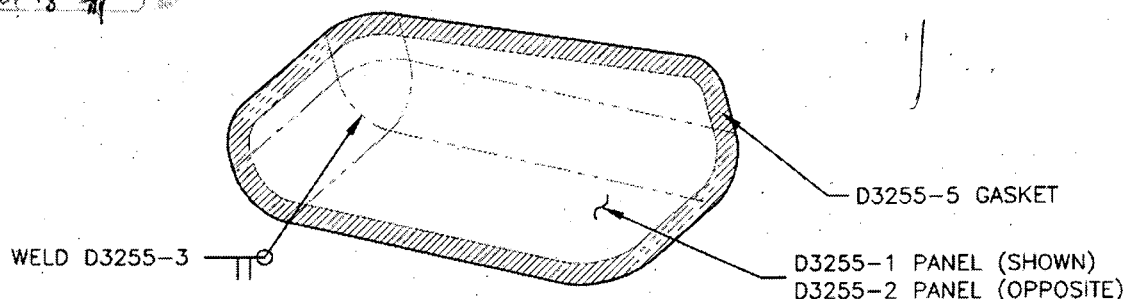
ES 11/02/23

3

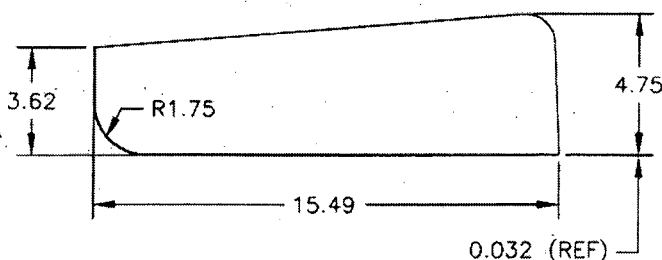
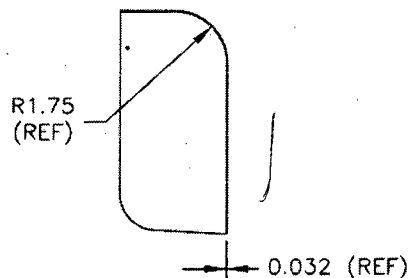
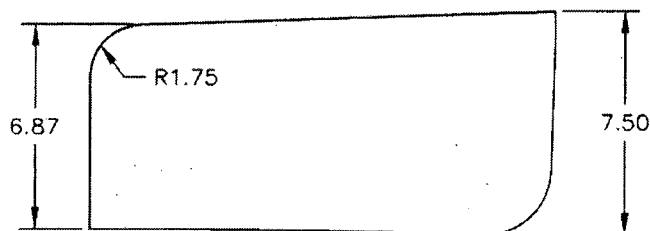


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED $\phi 0.098$	

RELEASED
05-01-18 #



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



WLO 66491

D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

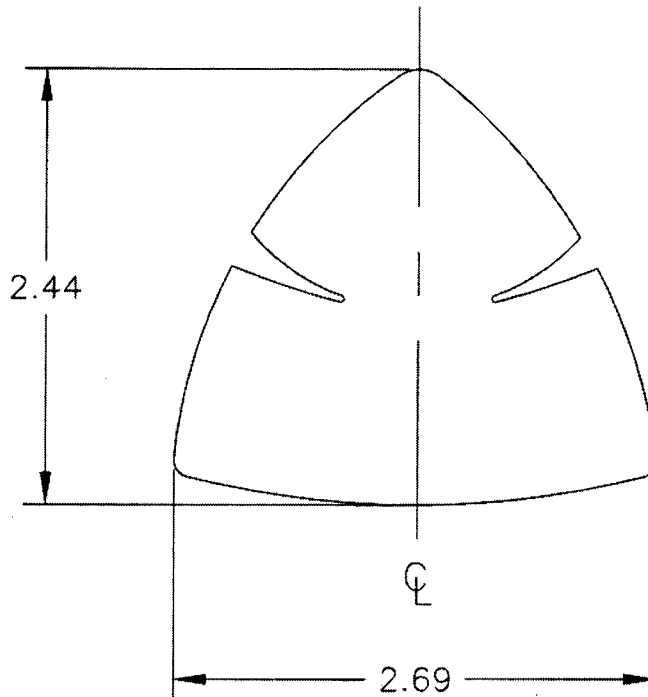
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DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED
05-01-08 [Signature]



D3255-3 CAP
FORM TO FIT D3155-1/-2

66491

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

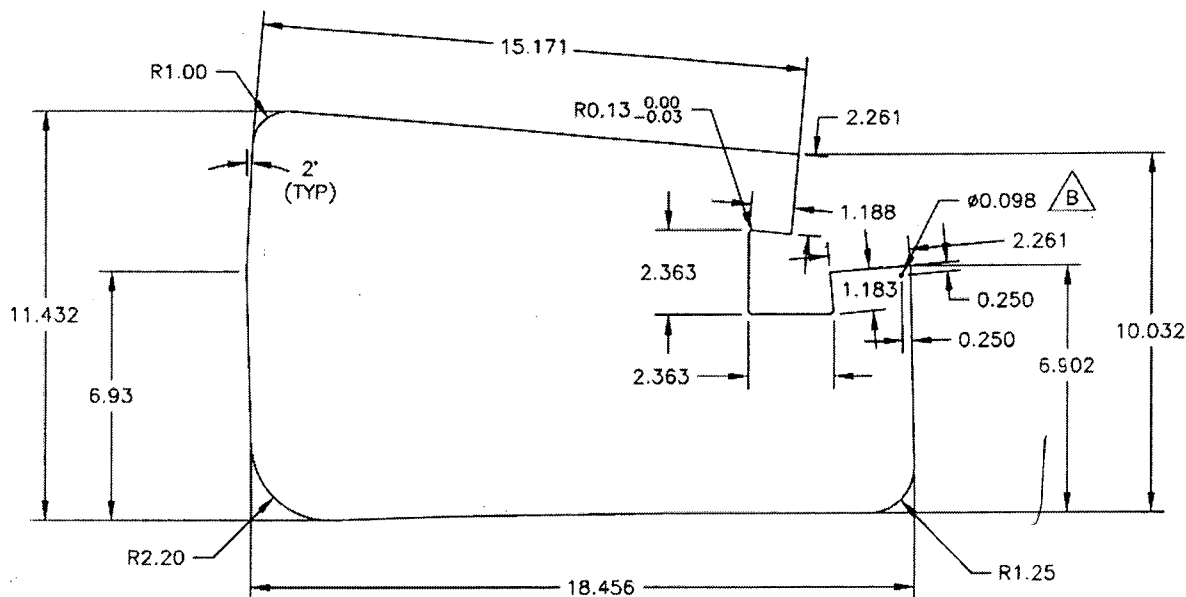
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DESIGN 7BF	DRAWN BY 7BF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED H	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05-01-18



D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

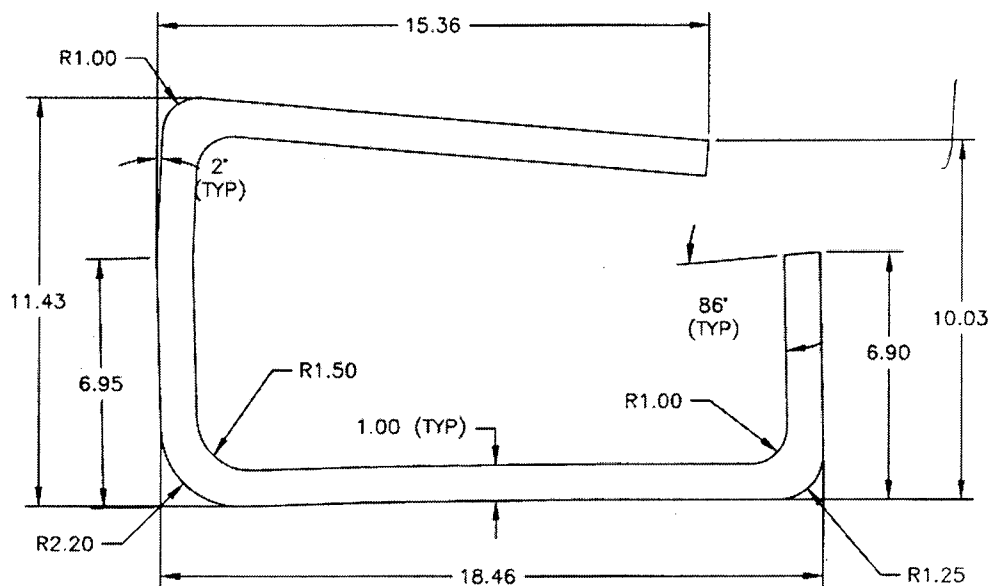
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DESIGN FF	DRAWN BY FF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED #	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
DS 0118 #



D3255-5 GASKET

666491

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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